Work Order ID 73048

Wednesday, August 24, 2011 3:34:25 PM

Item ID: D2279 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step Spacer

Start Date: 8/25/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 9/8/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** MK **Date:** 11-08-29 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2279 / Rev D									
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-8-29			
FLOW CNC Waterjet	1-Cut as per Dwg D 2279 ☐Dwg Rev: D ☐Prog Rev: D ☐2-Deburr if necessary								23
2024.040									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-8-29			
Quality Control									
120	QC8- Inspect parts - second check	0.00				counter			
QC	**Memo**	0.00				22	2		P10
Quality Control									

S 11/08/29

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W/O: 73048	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 77279 PAR #: N/A Fault Category: Small Fab. Wate Jet NCR: Yes No DQA: [illegible] Date: 11.09.08

11-897 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [illegible] Date: 11/09/08

NCR:	WORK ORDER NON-CONFORMANCE (NCR) 15,98							
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11/08/29		Qty x2 Parts found to be scrap. holes are too large & have a extra hole.	11.08.29	Scrap + Destry Qty x2	11-8-29	11/08/29	11.08.29	11/08/29
		R.C. Parts move after w/J was finished its pass process	QS1042	No Realse				11/08/29

NOTE: Date & initial all entries

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Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
Brake NC	**Memo**	0.00				21			
Brake NC	Form As per Dwg D2279		SB 11/08/30						
140	QC5- Inspect part completeness to step on W/O	0.00				counted			
QC	**Memo**	0.00	S 11/08/31			421			
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				21	BL 11-9-1		
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73048

Wednesday, August 24, 2011 3:34:25 PM

Item ID: D2279 **Accept** **Setup Start**

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Start Date: 8/25/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 9/8/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 6-A	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

21X 11/04/01

11/08/01 (21X)

11/9/01

11-09-01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, August 24, 2011 3:34:22 PM

Work Order ID: 73048

Parent Item: D2279

Parent Item Name: Step Spacer

Start Date: 8/25/2011 **Required Date:** 9/8/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev: A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	181.9184	0.147	3.094737 B11-829			

Location	Loc Qty	Loc Code	
MAT022	181.918421		
112291	0.5		
112331	0.2		
113162	18.1		
117684	163.118421		117684

03

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	73048
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.005	.252	✓		V BGR	
2.214	+/-0.005	2.214	✓		V	
4.178	+/-0.005	4.180	✓		V	
4.428	+/-0.010	4.435	✓		V	
0.250	+/-0.005	.251	✓		V	
1.313	+/-0.005	1.312	✓		V	
3.313	+/-0.005	3.313	✓		V	
4.625	+/-0.010	4.626	✓		V	
Ø0.128	+0.005/-0.000	.130	✓		V	
Ø1.250	+0.005/-0.000	1.250	✓		V	
R0.125	+/-0.010	.125	✓		R.G	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-8-24	Date:	11/05/24	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

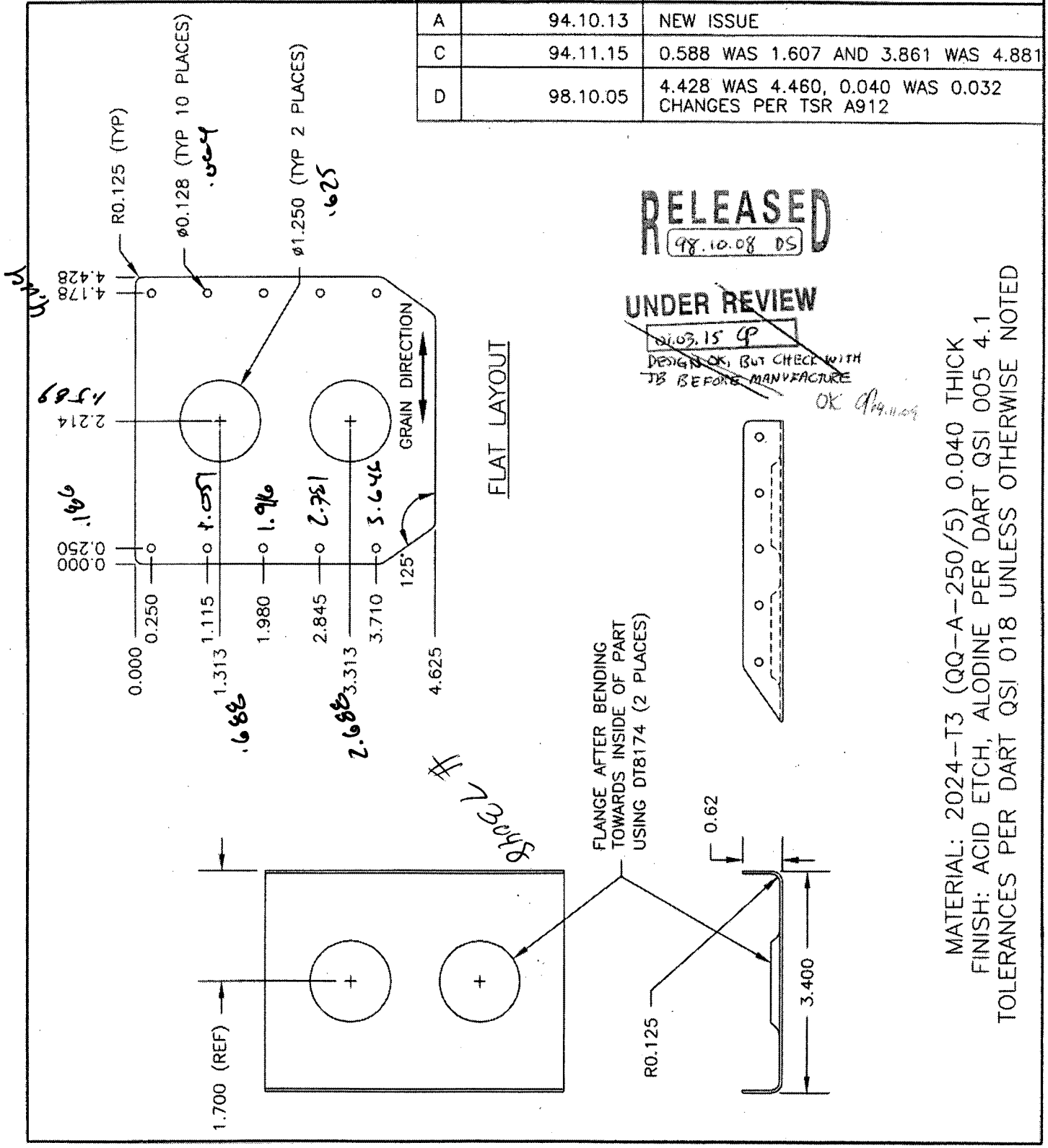
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	CP	
CHECKED	APPROVED	DRAWING NO. REV. D
RE	RH	D2279 SHEET 1 OF 1
DATE		TITLE SCALE
98.10.05		STEP SPACER 1:2

A	94.10.13	NEW ISSUE
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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